

WHAT IS CLAIMD IS:

1. A weather strip having an extrusion portion, and a molded portion connected to the extrusion portion, the weather strip comprising:

a mounting base portion attachable to an opening portion or a door circumferential edge of a vehicle;

a seal portion that is integrally formed with the mounting base portion and has a hollow portion;

a slit for taking out a core mold being formed in the mounting base portion of the molded portion when performing molding; and

at least one blocking piece, provided in a zone in which the slit is formed, wherein the blocking piece comprises:

a base piece portion formed in such a manner as to extend from a mounting face of the mounting base portion;

an insertion portion formed integrally with the base piece portion and fitted into the slit by bending the base piece portion around a part thereof continuously connected to the mounting base portion; and

a lock portion to be locked on an inner surface of the mounting base portion, which faces the hollow portion, when the insertion portion is fitted thereinto.

2. A weather strip according to claim 1, wherein:

the lock portion is locked by an inner surface of the

mounting base portion, opposite to a side, on which the base piece portion is formed, across the slit.

3. A weather strip according to claim 1, wherein the lock portion comprises:

a first lock part, locked by an inner surface of the mounting base portion, opposite to a side, on which the base piece portion is formed, across the slit; and

a second lock part locked by an inner surface of the mounting base portion at the side, on which the base piece portion is formed.

4. A weather strip according to claim 2, wherein:

a sandwich-holding projection portion for sandwich-holding, when the insertion portion is fitted into the slit, a part of the mounting base portion, opposite to a side, on which the base piece portion is formed, in conjunction with the lock portion is provided at the base piece portion.

5. A weather strip according to claim 1, wherein:

a tapered surface is formed on a part extending from a substantially tip end part of the insertion portion to the lock portion.

6. A weather strip according to claim 1, wherein:

thickness of the insertion portion is set to be substantially equal to width of the slit.

7. A weather strip according to claim 1, wherein: when the insertion portion is fitted into the slit, a surface of the base piece portion is connected with the mounting face of the mounting base portion substantially over the whole area, so that the base piece portion constitutes a part of the mounting base portion.

8. A method for manufacturing a weather strip having a mounting base portion attachable to an opening portion or a door circumferential edge of a vehicle, and also having a seal portion that is integrally formed with the mounting base portion and has a hollow portion, comprising steps of:
molding an extrusion portion by extrusion-molding;
forming a cavity, used for forming a molded portion, by a mold apparatus having at least a stationary mold, a movable mold, and a core mold equipped with a core body for forming the hollow portion, and of setting an extending plate, which extends from the core body, to extend from the cavity outwardly;
fixing the extrusion portion to the mold apparatus so that an end face of the extrusion portion faces the cavity;
injecting and filling rubber material, which is in a plasticized state, in the cavity;

separating, upon completion of solidification of the rubber material, the movable mold from the stationary mold, and of removing a molded portion precursor, which is molded by the solidification, together with the core mold; and

taking out the core body from a slit, from which at least the extending plate projects, in the molded portion precursor, and by further comprising steps of:

integrally forming, when the molded portion precursor is molded, at least one blocking piece, which corresponds to a zone set in the slit, with the molded portion precursor; and

obtaining the molded portion by bending, after the step of taking out the core body, the blocking piece around a base portion thereof thereby to fit a part of the blocking piece into the slit and to lock an end portion of the blocking piece by an inner surface of the molded portion precursor, which faces the hollow portion.

9. A method for manufacturing a weather strip according to claim 8, wherein:

when the step of obtaining the molded portion is performed, a step of bonding a predetermined part of the blocking piece to the molded portion precursor is performed.

10. A method for manufacturing a weather strip according to claim 8, wherein:

a plurality of the blocking pieces are formed; and each of the blocking pieces is formed along a direction, in which the movable mold for forming the blocking piece are separated from the stationary mold, in such a way as to extend from the molded portion precursor.

11. A method for manufacturing a weather strip according to claim 8, wherein:

at least a side portion of the blocking piece is tapered in a direction, in which the movable mold for molding the blocking piece is separated from the stationary mold.

12. A method for manufacturing a weather strip having a mounting base portion attachable to an opening portion or a door circumferential edge of a vehicle, and also having a seal portion that is integrally formed with the mounting base portion and has a hollow portion, comprising steps of:

molding an extrusion portion by extrusion-molding; forming a cavity, used for forming a molded portion, by a mold apparatus having at least a stationary mold, a movable mold, and a core mold equipped with a core body for forming the hollow portion, and of setting an extending plate, which extends from the core body, to extend from the cavity outwardly; fixing the extrusion portion to the mold apparatus so that an end face of the extrusion portion faces the cavity;

injecting and filling rubber material, which is in a plasticized state, in the cavity to form a molded portion precursor;

integrally forming, when the molded portion precursor is molded, at least one blocking piece, which corresponds to a zone set in a slit, with the molded portion precursor, wherein the blocking piece comprises: a base piece portion formed in such a manner as to extend from a mounting face of the mounting base portion; an insertion portion formed integrally with the base piece portion and fitted into the slit by bending the base piece portion around a part thereof continuously connected to the mounting base portion; and a lock portion to be locked on an inner surface of the mounting base portion, which faces the hollow portion, when the insertion portion is fitted thereinto;

separating, upon completion of solidification of the rubber material, the movable mold from the stationary mold, and of removing the molded portion precursor, which is molded by the solidification, together with the core mold; and

taking out the core body from the slit, from which at least the extending plate projects, in the molded portion precursor.

13. A method for manufacturing a weather strip according to Claim 12, further comprising:

a step of obtaining the molded portion by bending, after the step of taking out the core body, the blocking piece around

a base portion thereof thereby to fit a part of the blocking piece into the slit and to lock an end portion of the blocking piece by an inner surface of the molded portion precursor, which faces the hollow portion.